

Date: Tuesday, 4/17/2007 11:07:42 AM  
User: Kim Johnston

# Process Sheet

|                       |                                       |                  |                             |
|-----------------------|---------------------------------------|------------------|-----------------------------|
| Customer              | : CU-DAR001 Dart Helicopters Services | Drawing Name     | : MID TUBE ASSEMBLY         |
| Job Number            | : 31845                               |                  |                             |
| Estimate Number       | : 10469                               |                  |                             |
| P.O. Number           | : N/A                                 | Part Number      | : D3391023                  |
| This Issue            | : 4/17/2007 S.O. No. : N/A            | Drawing Number   | : D3391 REV F               |
| Prsht Rev.            | : NC                                  | Project Number   | : N/A                       |
| First Issue           | : N/A Type : LANDING GEAR             | Drawing Revision | : F                         |
| Previous Run          | : 31844                               | Material         | : N/A                       |
| Written By            | :                                     | Due Date         | : 5/20/2007 Qty: 1 Um: Each |
| Checked & Approved By | : <u>07.04.17</u>                     |                  |                             |
| Comment               | : Est. A 05.10.20 New Issue KJ/EC     |                  |                             |
|                       | : Est. B 06.02.10 ECN773 dwg rev.D EC |                  |                             |
|                       | : est C 07.03.20 rev F dwg EC         |                  |                             |
|                       | : est D 07.03.28 re-format EC         |                  |                             |

## Additional Product

Job Number:



|         |                       |               |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

|     |           |                    |
|-----|-----------|--------------------|
| 1.0 | D25001100 | Skidtube Extrusion |
|-----|-----------|--------------------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
SKIDTUBE EXTRUSION

Pick:

|     |             |             |
|-----|-------------|-------------|
| Qty | Part Number | Description |
| 1   | D2500-1-100 | Extrusion   |

Batch

B24593

DP 7-4-19

|     |          |                   |
|-----|----------|-------------------|
| 2.0 | D3391021 | Fwd Tube Assembly |
|-----|----------|-------------------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
Fwd Tube Assembly

Batch:

B 31851

|     |                |                         |
|-----|----------------|-------------------------|
| 3.0 | LANDING GEAR 1 | LANDING GEAR RESOURCE 1 |
|-----|----------------|-------------------------|



Comment: LANDING GEAR RESOURCE 1

1-Cut tube to finish length as per Dwg D3391

DP 7-4-19

2-Identify as D3391-023

3-Drill pilot holes using DT8796 (Do not drill "B" holes) and drill only 1 fwd saddle hole on one side only as per Dwg D3391

4-Open float bag holes 0.257" as per Dwg D3391

5-C'sink float bag holes as per Dwg D3391

6-Open remaining holes to Ø0.375" except for fwd saddle hole of detail "J"

DP  
7-5-3

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

Date: Tuesday, 4/17/2007 11:07:42 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MID TUBE ASSEMBLY

Job Number: 31845

Part Number: D3391023

Job Number:



Seq. #:

Machine Or Operation:

Description :

7-Remove .030" from Fwd indexing Ridge as per Dwg D3391

8-Remove indexing ridge on Fwd & Aft end of skidtube as per Dwg D3391

9-Deburr

10-Drill #30 pilot holes using wearplate Jig DT8217 Identify Ø0.250" holes with paint marker,

11-Open wearplate holes of D3391-023 assembly detail section G-G to Ø0.250" (14 holes) as per Dwg D3391 and 2 holes in section Detail "J", do not open wearplate holes of section "J"

12-Open wearplate holes of D3391-023 assembly detail section H-H to Ø0.257" and c'sink (20 holes) as per Dwg D3391

13-Open .375" holes to .438" \*\*\*do not open fwd saddle holes\*\*\*

14-Locate D3391-021 in D3391-023 at 9.00" (see view z-z)

15- Transfer drill one fwd saddle hole only to .188" dia, transfer drill all remaining fwd saddle holes using DT 8149 locating from previously drill .188" dia hole, using t-pins and clicos to ensure perfect allingment, open up previously tranfer drilled pilot holes in D3391-023/-021 to 0.438" dia. in D3391-021

16- Transfer drill 2 wearplate holes into D3391-021 using DT8217, locating from two previously drilled holes, drill remaining wearplate holes into D3391-021.

17- Locating from two fwd wearplate holes drillol remaining 6 wearplte holes in D3391-021 using DT8937

18- Open 2 fwd wearplate holes in D3391-023 to .250" dia.

19- Open 12 wearplate holes in D3391-021 to 0.257" dia.

20-Deburr and blow out all chips from inside tube

4.0

QC5

INSPECT WORK TO CURRENT STEP



7405250



Comment: INSPECT WORK TO CURRENT STEP

5.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

Job 7-5-29

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

Date: Tuesday, 4/17/2007 11:07:42 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MID TUBE ASSEMBLY

Job Number: 31845

Part Number: D3391023

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



*Intox-290*



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

7.0

D33891

Web



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEB

Pick:

Qty

Part Number

Description

Batch

1

D3389-1

Web

*B32291*

AR

Sikaflex-241/-291

*m103 561*

Sikaflex expire date:

*7-10-07*

Start: *10:10* Time: *7-5-29*

Finish: *07:05:30* Time: *7:20 AM*

*50 7-5-29*

8.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

2-Bond web in place as per Dwg D3391 & QSI 015.

Adhere for 12 hours)

*50 7-5-29*

9.0

QC5

INSPECT WORK TO CURRENT STEP



*Intox-300*



Comment: INSPECT WORK TO CURRENT STEP

10.0

POWDER COATING

POWDER COATING



*M 105068*



*①*

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

*BR/M. 07-08-16*

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*FL 07/08/17 ①*

12.0

NAS1330C3KB116

Insert



*①*

Comment: Qty.: 20.0000 Each(s)/Unit Total : 20.0000 Each(s)

Insert

Pick:

Qty

Part Number

Description

Batch

20

NAS1330C3KB116

Insert

*m100712*

*07/08/18*  
*FL/M. h*

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 08/08/22  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

Date: Tuesday, 4/17/2007 11:07:42 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MID TUBE ASSEMBLY

Job Number: 31845

Part Number: D3391023

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

NAS1330C3KB166

INSERT



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

RivnuT

Pick:

Qty Part Number

Description

Batch

10

NAS1330C3KB166

Insert

m103279.

m. H. FL.

14.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Install inserts as per dwg D3391

touch-up holes in D3391-021 with alodine

FL 07/08/17 (1)

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Inspect each insert using DT8821

En 07/08/17 (1)

16.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

33526A

17.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

FL 07/08/22 (1)

Job Completion



07.08.22

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

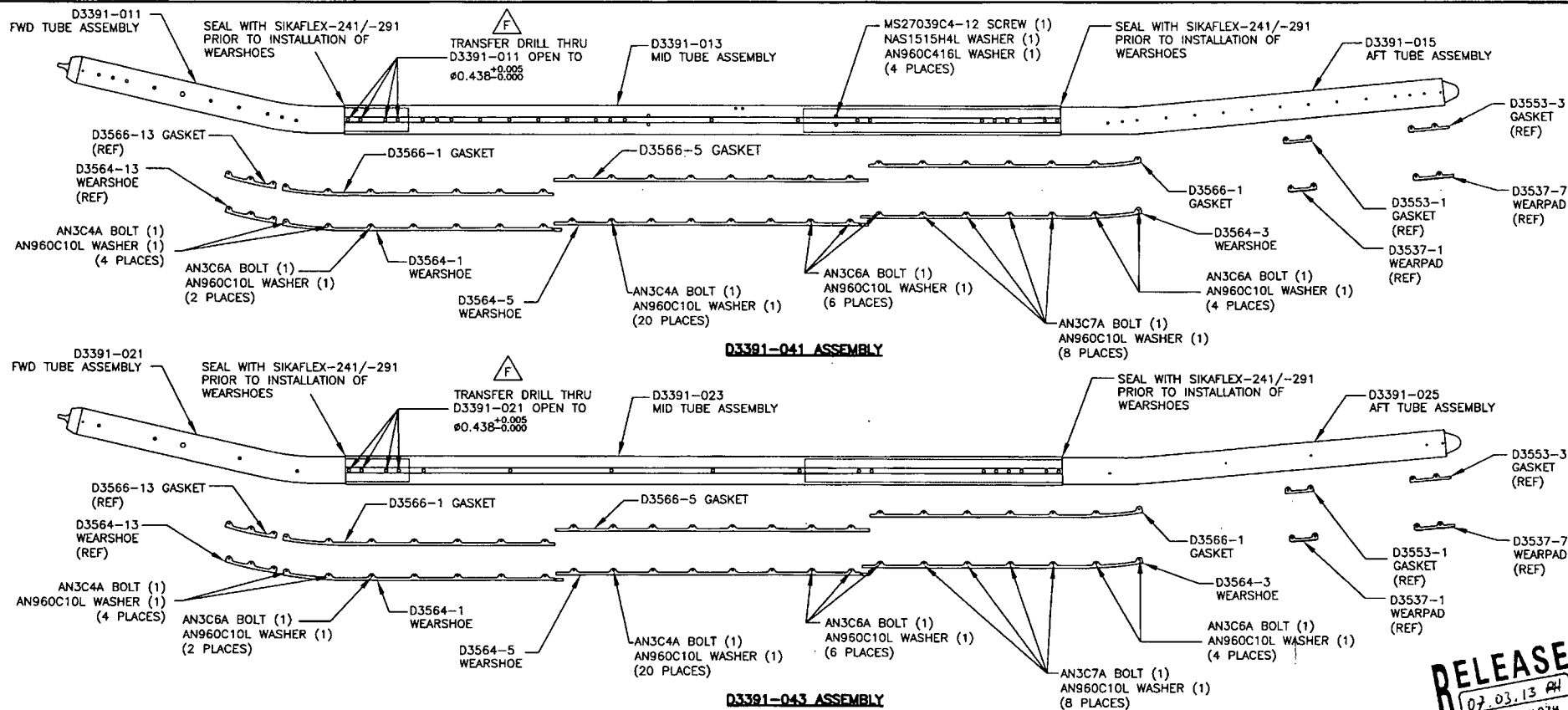
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries





#### D3391-041/-043 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

| QTY | D3391-041 | QTY | D3391-043 | PART NUMBER  | DESCRIPTION             |
|-----|-----------|-----|-----------|--------------|-------------------------|
| 1   | X         | 1   | X         | D3391-041    | FLOAT SKIDTUBE ASSEMBLY |
| 1   |           | 1   |           | D3391-043    | FLOAT SKIDTUBE ASSEMBLY |
| 1   |           | 1   |           | D3391-011    | FWD TUBE ASSEMBLY       |
| 1   |           | 1   |           | D3391-013    | MID TUBE ASSEMBLY       |
| 1   |           | 1   |           | D3391-015    | AFT TUBE ASSEMBLY       |
| 1   |           | 1   |           | D3391-021    | FWD TUBE ASSEMBLY       |
| 1   |           | 1   |           | D3391-023    | MID TUBE ASSEMBLY       |
| 1   |           | 1   |           | D3391-025    | AFT TUBE ASSEMBLY       |
| 1   |           | 1   |           | D3564-1      | WEARSHOE                |
| 1   |           | 1   |           | D3564-3      | WEARSHOE                |
| 1   |           | 1   |           | D3564-5      | WEARSHOE                |
| 2   |           | 2   |           | D3566-1      | GASKET                  |
| 1   |           | 1   |           | D3566-5      | GASKET                  |
| 24  |           | 24  |           | AN3C4A       | BOLT                    |
| 12  |           | 12  |           | AN3C6A       | BOLT                    |
| 8   |           | 8   |           | AN3C7A       | BOLT                    |
| 44  |           | 44  |           | AN960C10L    | WASHER                  |
| 4   |           | 4   |           | MS27039C4-12 | SCREW                   |
| 4   |           | 4   |           | NAS1515H4L   | WASHER                  |
| 4   |           | 4   |           | AN960C416L   | WASHER                  |

#### GENERAL NOTES

- ALL DIMENSIONS ARE IN INCHES
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY. CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL 'E' SIZE HOLES (0.250-0.257) FOR WEARSHOE INSERTS. C'SINK 0.391/0.425 x 100" AS APPLICABLE AND INSTALL INSERTS EXCEPT WHERE INDICATED.

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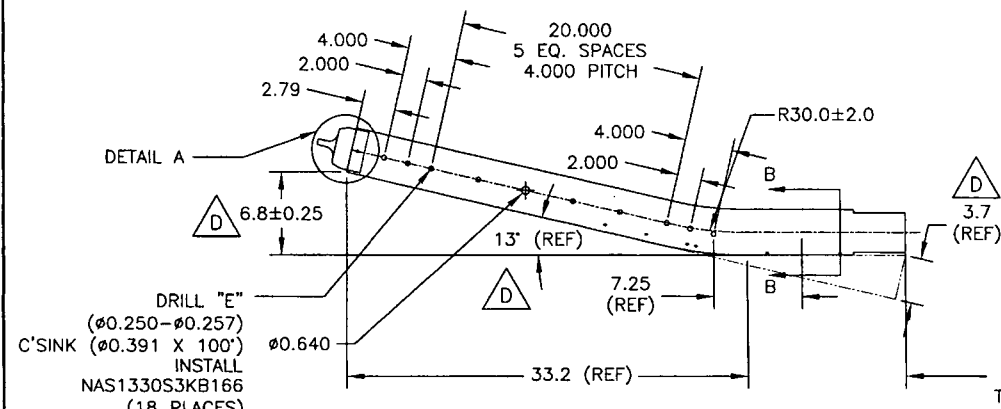
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|         |          |   |
|---------|----------|---|
| F       | 07.01.18 | ADD SS WEARSHOE, GASKET<br>REMOVE FWD SADDLE HOLE -011/-021 |
| E       | 06.04.25 | CHANGE TOLERANCE, EASE MANUFACTURE                          |
| D       | 06.01.23 | UPDATE TOLERANCE, CHANGE HOLE SIZE                          |
| C       | 05.09.27 | LENGTHEN AFT EXTENSION                                      |
| B       | 05.06.10 | DRAWING UPDATES   |
| A       | 05.02.07 | NEW ISSUE   |
| DESIGN  | PH       | DRAWN BY PH   |
| CHECKED | PH       | APPROVED PH   |
| DATE    | 07.01.18 | DRAWING NO. D3391   |
|         |          | TITLE 412 FLOAT SKIDTUBE                                    |
|         |          | SCALE NTS   |

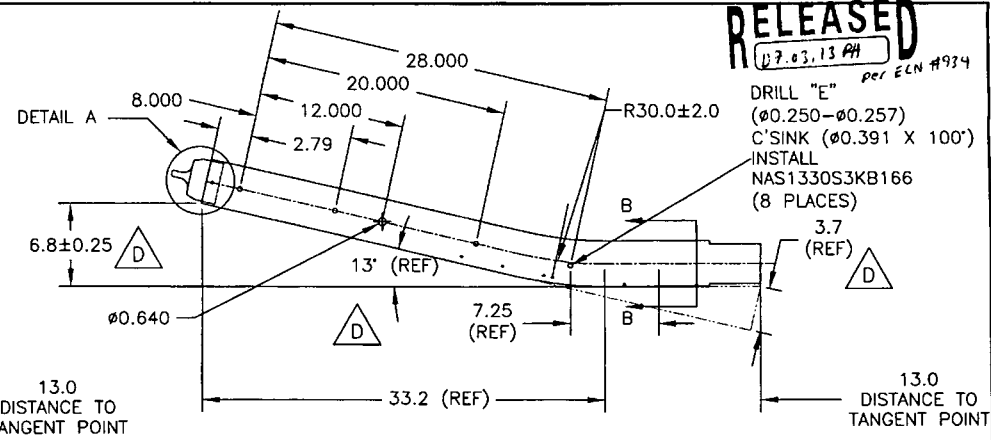
RELEASED  
07.03.13 AH  
per ECU #934

NOT FOR  
WORK ORDER  
51845  
SUBJECT TO ATTENDMENT  
WITHOUT NOTICE  
CONTROLLED COPY  
ENGINEERING  
RETURN TO  
SHOP COPY

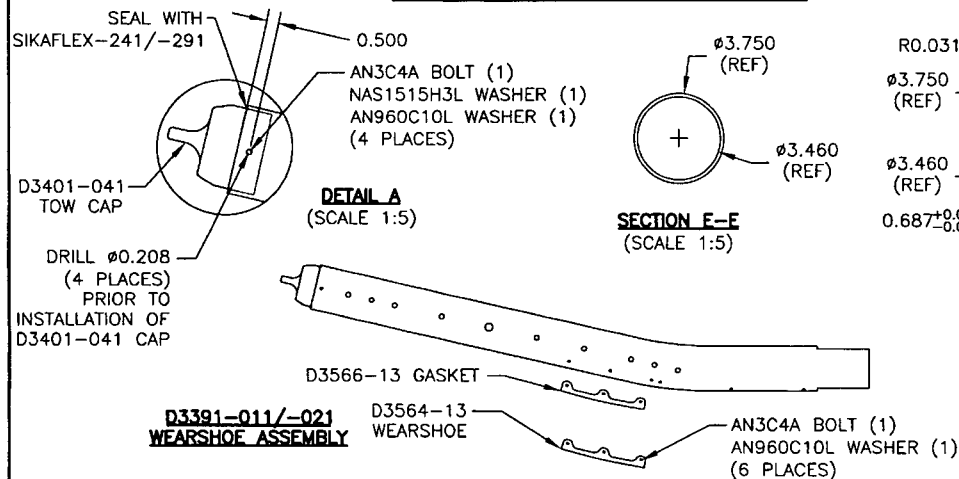
**RELEASED**  
 17.03.13 AH  
 per ECN #934



**D3391-011 ASSEMBLY AND BENDING DETAIL**



**D3391-021 ASSEMBLY AND BENDING DETAIL**



**D3391-011/-021 WEARSHOE ASSEMBLY**

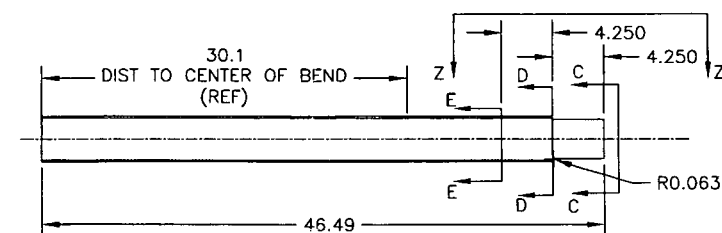
**D3391-011/-021 FWD TUBE ASSEMBLY PARTS LIST**

| QTY - 011 | QTY - 021 | PART NUMBER    | DESCRIPTION                |
|-----------|-----------|----------------|----------------------------|
| X         |           | D3391-011      | FWD TUBE ASSEMBLY          |
|           | X         | D3391-021      | FWD TUBE ASSEMBLY          |
| 1         | 1         | D6013-047      | FWD TUBE                   |
| 1         | 1         | D3401-041      | TOW CAP                    |
| 1         | 1         | D3564-13       | WEARSHOE                   |
| 1         | 1         | D3566-13       | GASKET                     |
| 10        | 10        | AN3C4A         | BOLT                       |
| 4         | 4         | NAS1515H3L     | WASHER                     |
| 10        | 10        | AN960C10L      | WASHER                     |
| 30        | 20        | NAS1330S3KB166 | INSERT (OR NAS1330C3KB166) |

SHOP COPY  
 RETURN TO  
 ENGINEERING  
 UNCONTROLLED COPY  
 SUBJECT TO AMENDMENT  
 WITHOUT NOTICE

DRILL 'E'  
 (Ø0.250-Ø0.257)  
 C'SINK (Ø0.391 X 100')  
 INSTALL  
 NAS1330S3KB166  
 (12 PLACES)

**SECTION B-B**  
 (SCALE 1:5)

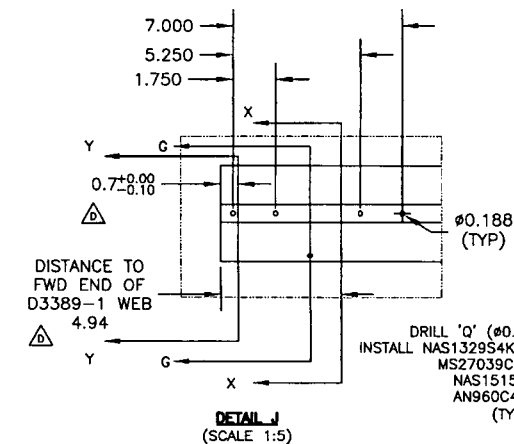
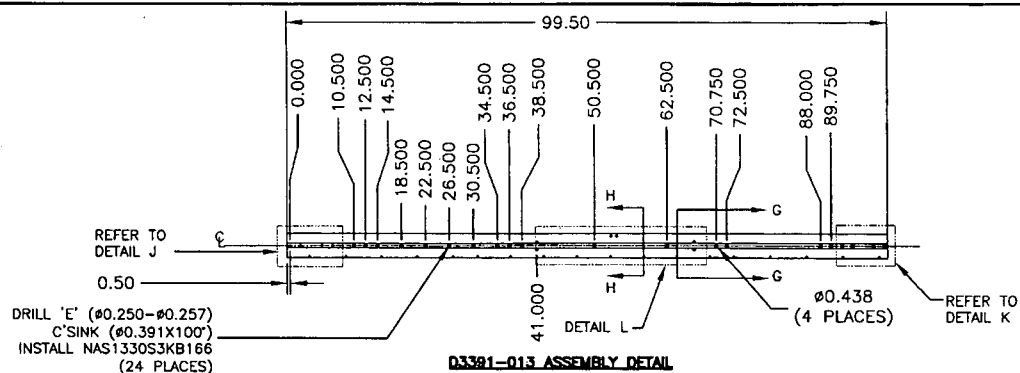


**D3391-1 DRILLING AND CUTTING DETAIL**  
 (MAKE FROM D6013-047 SKIDTUBE MATERIAL)

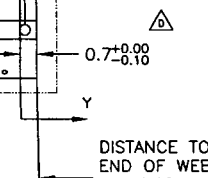
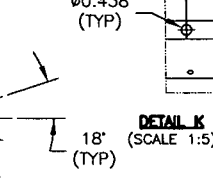
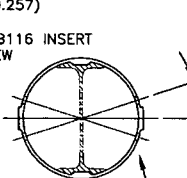
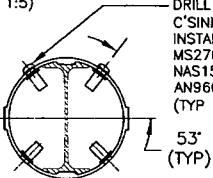
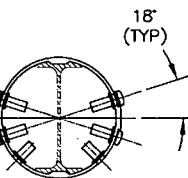
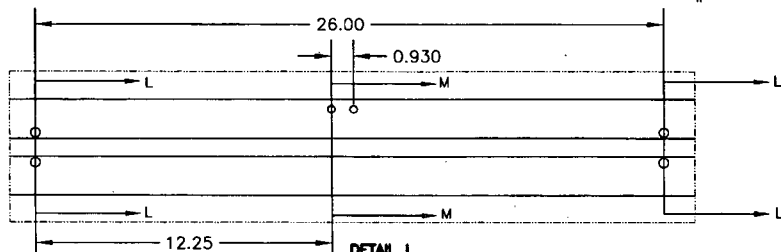
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|                  |                             |  |              |
|------------------|-----------------------------|--|--------------|
| DESIGN<br>PH     | DRAWN BY<br>AH              | <b>DART</b> DART AEROSPACE USA, INC.<br>PORT HADLOCK, WA | REV. F       |
| CHECKED<br>H     | APPROVED<br>H               | DRAWING NO.<br>D3391                                     | SHEET 2 OF 5 |
| DATE<br>07.01.18 | TITLE<br>412 FLOAT SKIDTUBE | SCALE<br>1:10  |              |



DRILL 'Q' (#0.332-#0.338)  
INSTALL NAS1329S4KB140 INSERT  
MS27039C4-08 SCREW  
NAS1515H4L WASHER  
AN960C416L WASHER  
(TYP 4 PLACES)



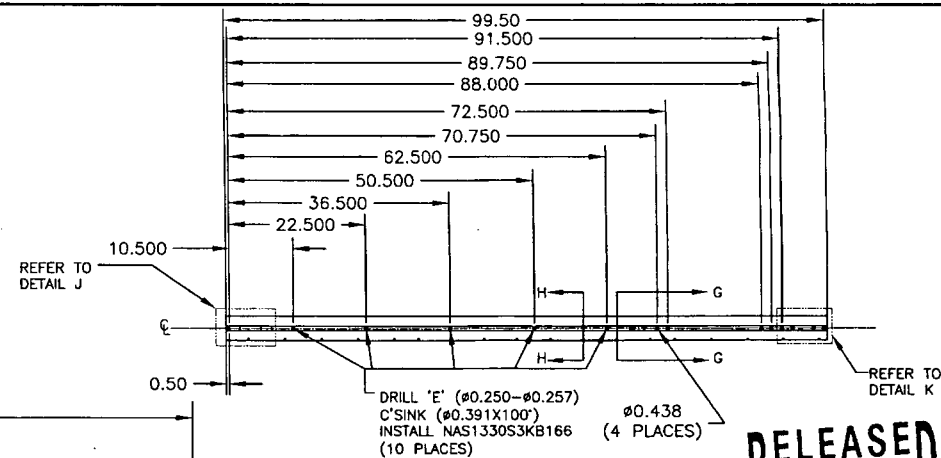
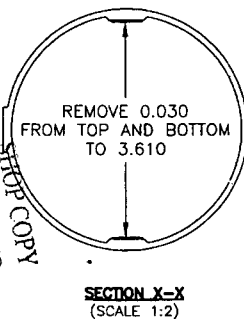
# **D3391-013/-023 MID TUBE ASSEMBLY PARTS LIST**

| QTY - 013 | QTY - 023 | PART NUMBER    | DESCRIPTION                |
|-----------|-----------|----------------|----------------------------|
| X         |           | D3391-013      | MID TUBE ASSEMBLY          |
|           | X         | D3391-023      | MID TUBE ASSEMBLY          |
| 1         | 1         | D2500-1-100    | EXTRUSION                  |
| 1         | 1         | D3389-1        | WEB                        |
| 24        | 20        | NAS1330S3KB116 | INSERT (OR NAS1330C3KB116) |
| 24        | 10        | NAS1330S3KB166 | INSERT (OR NAS1330C3KB166) |
| 4         |           | NAS1329S4KB140 | INSERT (OR NAS1329C3KB140) |
| 4         |           | NAS1515H3L     | WASHER                     |
| 4         |           | AN960C10L      | WASHER                     |
| 4         |           | NAS1515H4L     | WASHER                     |
| 4         |           | AN960C416L     | WASHER                     |
| 4         |           | MS27039C1-09   | SCREW                      |
| 4         |           | MS27039C4-08   | SCREW                      |

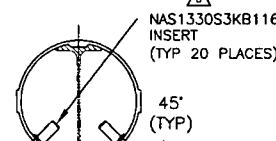
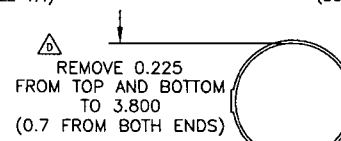
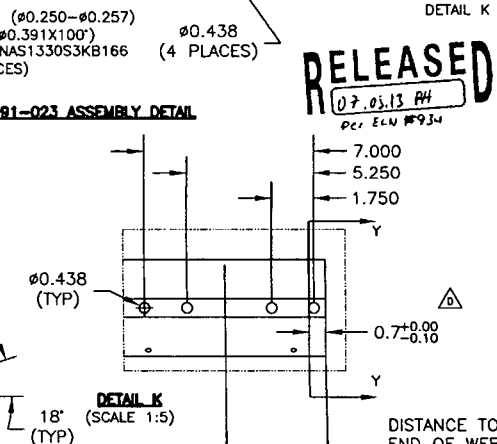
## **D3391-013/-023 MID TUBE ASSEMBLY**

- MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
- INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/-291 PER Q5701

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## **D3391-023 ASSEMBLY DETAIL**



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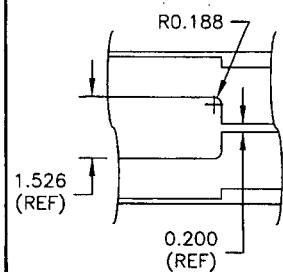
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DATE  
07.01.18

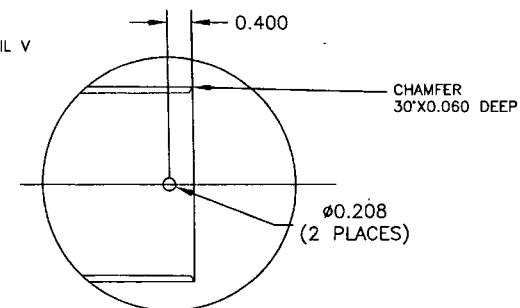
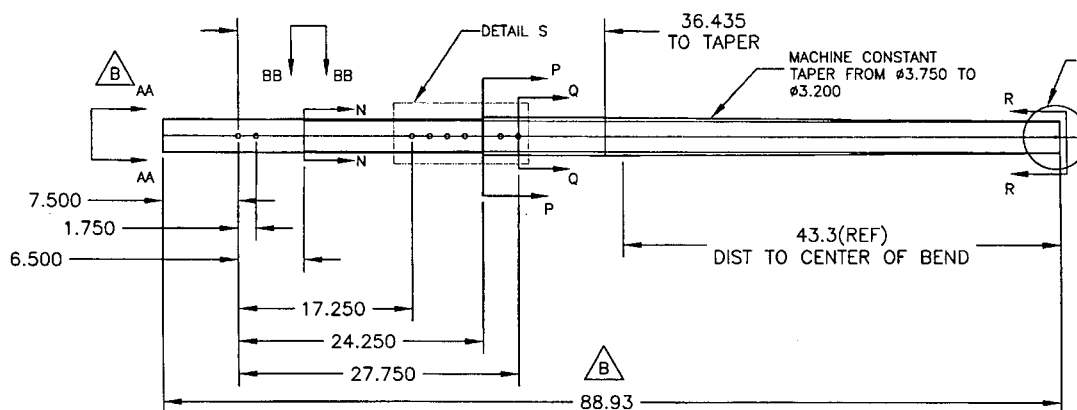
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D3391  
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1:20

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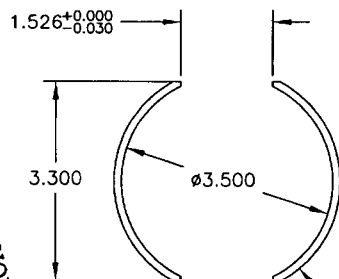


VIEW BB-BB  
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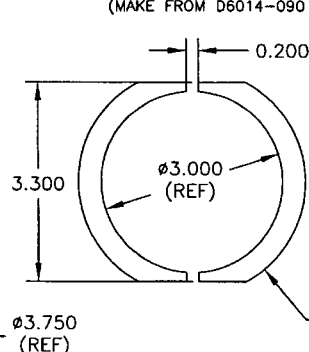


DETAIL V  
(SCALE 1:2)

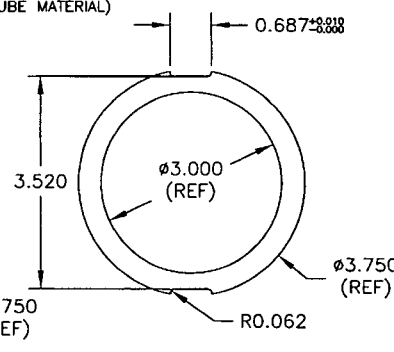
D3391-3 AFT DRILLING AND CUTTING DETAIL  
(MAKE FROM D6014-090 SKIDTUBE MATERIAL)



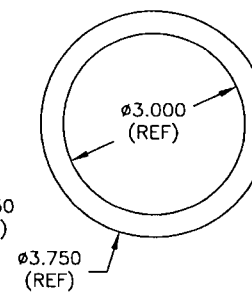
SECTION AA-AA  
(SCALE 1:2)



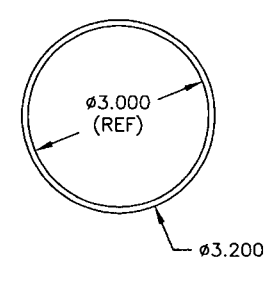
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SECTION P-P  
(SCALE 1:2)

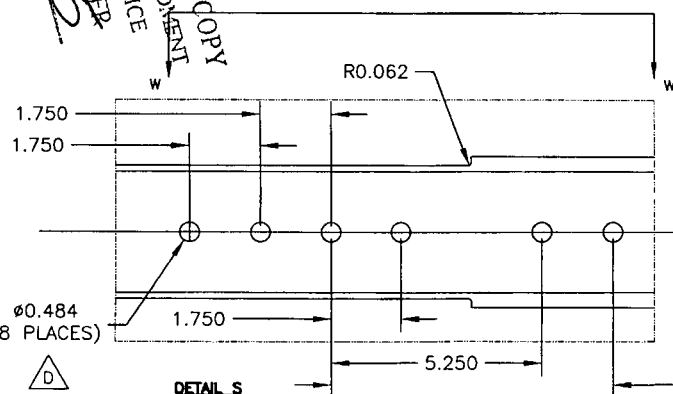


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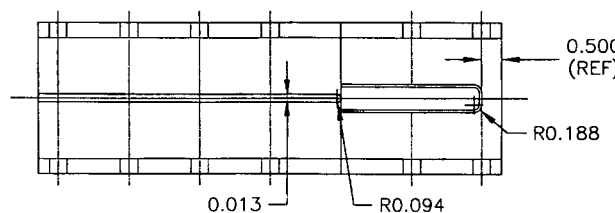


SECTION R-R  
(SCALE 1:2)

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DETAIL S  
(SCALE 1:3)



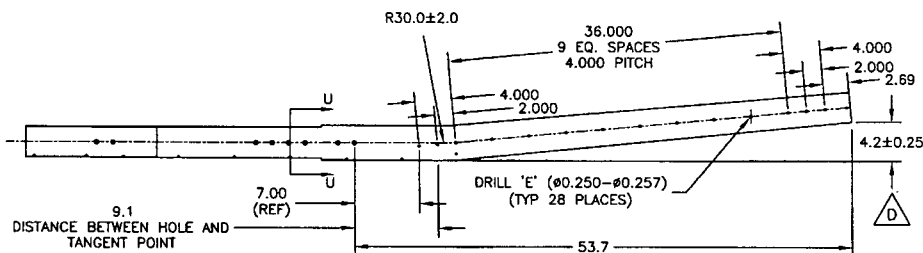
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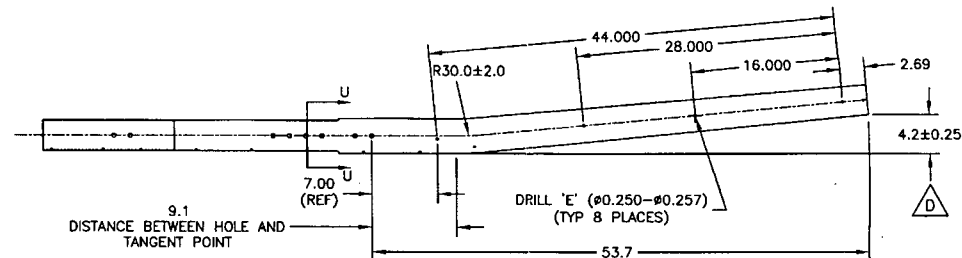
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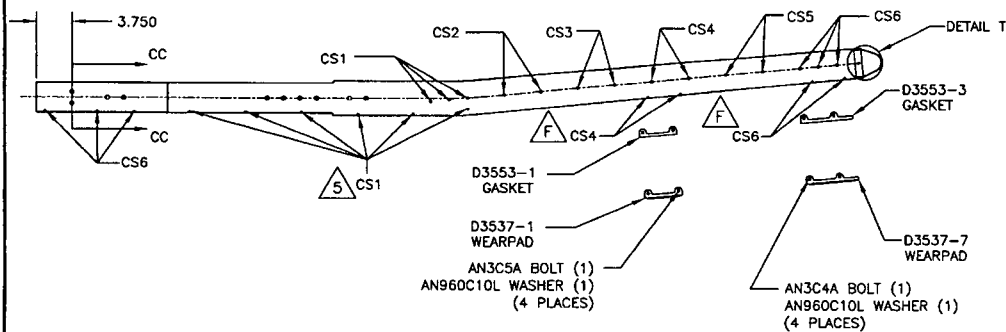
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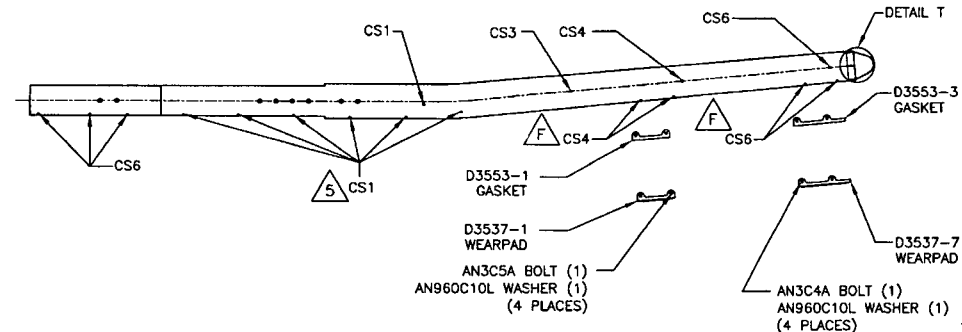
**D3391-015 BENDING AND ASSEMBLY DETAIL**



**D3391-025 BENDING AND ASSEMBLY DETAIL**



**D3391-015 INSERT AND WEARPAD INSTALLATION DETAIL**  
(SEE TABLE)

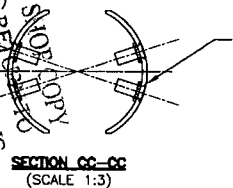


**D3391-025 INSERT AND WEARPAD INSTALLATION DETAIL**  
(SEE TABLE)

**D3391-015/-025 AFT TUBE ASSEMBLY PARTS LIST**

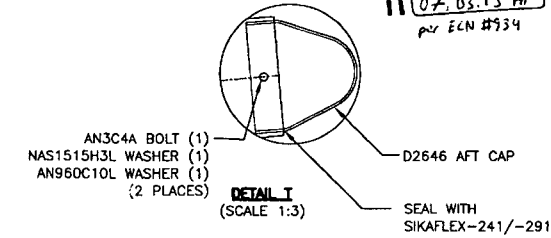
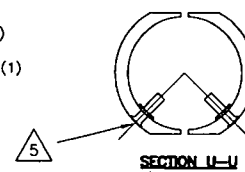
| QTY - 015 | QTY - 025 | PART NUMBER    | DESCRIPTION                |
|-----------|-----------|----------------|----------------------------|
| X         | X         | D3391-015      | AFT TUBE ASSEMBLY          |
|           |           | D3391-025      | AFT TUBE ASSEMBLY          |
| 1         | 1         | D6014-090      | AFT TUBE                   |
| 1         | 1         | D2646          | AFT CAP                    |
| 1         | 1         | D3537-1        | WEARPAD                    |
| 1         | 1         | D3537-7        | WEARPAD                    |
| 1         | 1         | D3553-1        | GASKET                     |
| 1         | 1         | D3553-3        | GASKET                     |
| 18        | 14        | NAS1330S3KB366 | INSERT (OR AES10KB366)     |
| 4         | 2         | NAS1330S3KB316 | INSERT (OR NAS1330C3KB316) |
| 8         | 6         | NAS1330S3KB266 | INSERT (OR NAS1330C3KB266) |
| 4         |           | NAS1330S3KB216 | INSERT (OR NAS1330C3KB216) |
| 16        | 12        | NAS1330S3KB166 | INSERT (OR NAS1330C3KB166) |
| 4         |           | NAS1330S4KB151 | INSERT (OR NAS1330C4KB151) |
| 6         | 6         | AN3C4A         | BOLT                       |
| 4         | 4         | AN3C5A         | BOLT                       |
| 2         | 2         | NAS1515H3L     | WASHER                     |
| 10        | 10        | AN960C10L      | WASHER                     |

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C'SINK AND INSTALL NAS1330S3KBXXX IN HOLES MARKED CS1-CS6 AS FOLLOWS

| HOLES MARKED | QTY D3391-015 | QTY D3391-025 | C'SINK | P/N            |
|--------------|---------------|---------------|--------|----------------|
| CS1          | 18            | 14            | Ø0.425 | NAS1330S3KB366 |
| CS2          | 4             |               | Ø0.391 | NAS1330S3KB366 |
| CS3          | 4             | 2             | Ø0.391 | NAS1330S3KB316 |
| CS4          | 8             | 6             | Ø0.391 | NAS1330S3KB266 |
| CS5          | 4             |               | Ø0.391 | NAS1330S3KB216 |
| CS6          | 16            | 12            | Ø0.391 | NAS1330S3KB166 |



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|   |  |                             |                |  |
|---|--|-----------------------------|----------------|--|
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